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190939
RBEM622V4008101-5
Job Sheet R190943



Part No: RBEM622V4008101-5

Job Qty: 4 pcs

Part Name: Support 1



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 2/20/19

Job Tracking No:

Due Date: 2/20/19

Created By: Linda Lacelle

Type: Rework

Description:

Note: DWG RBEM622V4008101 Rev. 3 IPP Rev. A 18.05.18 new issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
120	NV5000 - 1 <i>rework to Rev D</i>	4 pcs	2/20/19	2/20/19	0.00	2.67	NV5000 - 1		<i>//</i>
							NV5000 - 2		
130	QC 2	4 pcs	2/20/19	2/20/19	0.00	0.00	QC 2 - 1		
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		
							QC 2 - 54		
							QC 2 - 56		
							QC 2 - 57		
							QC 2 - 62		
							QC 2 - 63		
							QC 2 - 8		<i>// 19/2/20</i>



Container No: S155272



Part: RBEM622V4008101-5

Job No: R190943

Serial No/Batch: S155272

Revision: D

Inspector:

Exp Date:

Instructions:

Dart Aerospace Ltd.
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CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Date: 02/20/19

140	QC 8	4 pcs	2/20/19	0.00 0.00	QC 2 - 66	
					QC 2 - 64	
					QC 8 - 12	
					QC 8 - 14	
					QC 8 - 17	
					QC 8 - 20	
					QC 8 - 25	
					QC 8 - 3	
					QC 8 - 32	
					QC 8 - 33	
					QC 8 - 35	
					QC 8 - 39	
					QC 8 - 4	
					QC 8 - 44	
					QC 8 - 45	
					QC 8 - 49	
					QC 8 - 58	
					QC 8 - 8	
					QC 8 - 9	
					QC 8 - 68	
					QC 8 - 67	
					QC 8 - 1 (A)	
					QC 8 - 47	
150	Powdercoat - 13 Yellow - B4B	4 pcs	2/20/19	0.00 0.40	Powdercoat - 1 - B4B	
					Powdercoat - 2 - B4B	
					Powdercoat - 3 - B4B	
					Powdercoat - 4 - B4B	
160	QC 3	4 pcs	2/20/19	0.00 0.00	QC 3 - 10	
					QC 3 - 13	
					QC 3 - 15	
					QC 3 - 17	
					QC 3 - 18	
					QC 3 - 2	
					QC 3 - 26	
					QC 3 - 28	
					QC 3 - 3	
					QC 3 - 30	
					QC 3 - 34	
					QC 3 - 36	
					QC 3 - 41	
					QC 3 - 51	
					QC 3 - 58	
					QC 3 - 59	
					QC 3 - 6	
					QC 3 - 68	
					QC 3 - 9	
170	Packaging 3-1 - Stock - B4B	4 pcs	2/20/19	0.00 0.00	Packaging 3 - 1 - B4B	
					Packaging 3 - 2 - B4B	
					Packaging 3 - 3 - B4B	
					Packaging 3 - 4 - B4B	
					Packaging 3 - 5 - B4B	
					Packaging 3 - 6 - B4B	
					Packaging 3 - 7 - B4B	
					Packaging 3 - 8 - B4B	
					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	
					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	
					Packaging 3 - 13 - B4B	

				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
180	QC 21 - SA	4 pcs	2/20/19	0.00 0.00	QC 21 - SA - 21
					QC 21 - SA - 70
					QC 21 - SA - 53

Part Op **120** - NV5000-2 (MORI SEIKI VERTICAL MACHINE #2) - 1-Machine as per folio FC187 FOLIO REV: _____
 Descriptions: DWG REV: _____ 2-Deburr 3-Cut blank at 4.25"
130 - QC2- Inspect parts off machine FAI/FAIB
140 - QC8- Inspect parts - second check
150 - Powdercoat13 - Yellow #13538 - START TIME: _____ OVEN TEMPERATURE: _____ FINISH TIME: _____
160 - QC3- Inspect Part Finish
170 - Identify as per dwg & Stock Location: _____
180 - QC21- Final Inspection - Work Order Release

Job BOM				
Part / Item	Component Name	Quantity	Operation	Container
M303B3.000X6.000	AISI 303 SS Bar 3.000" x 6.000"	1.6440 ft (.411 ea)	120-NV5000 - 1	

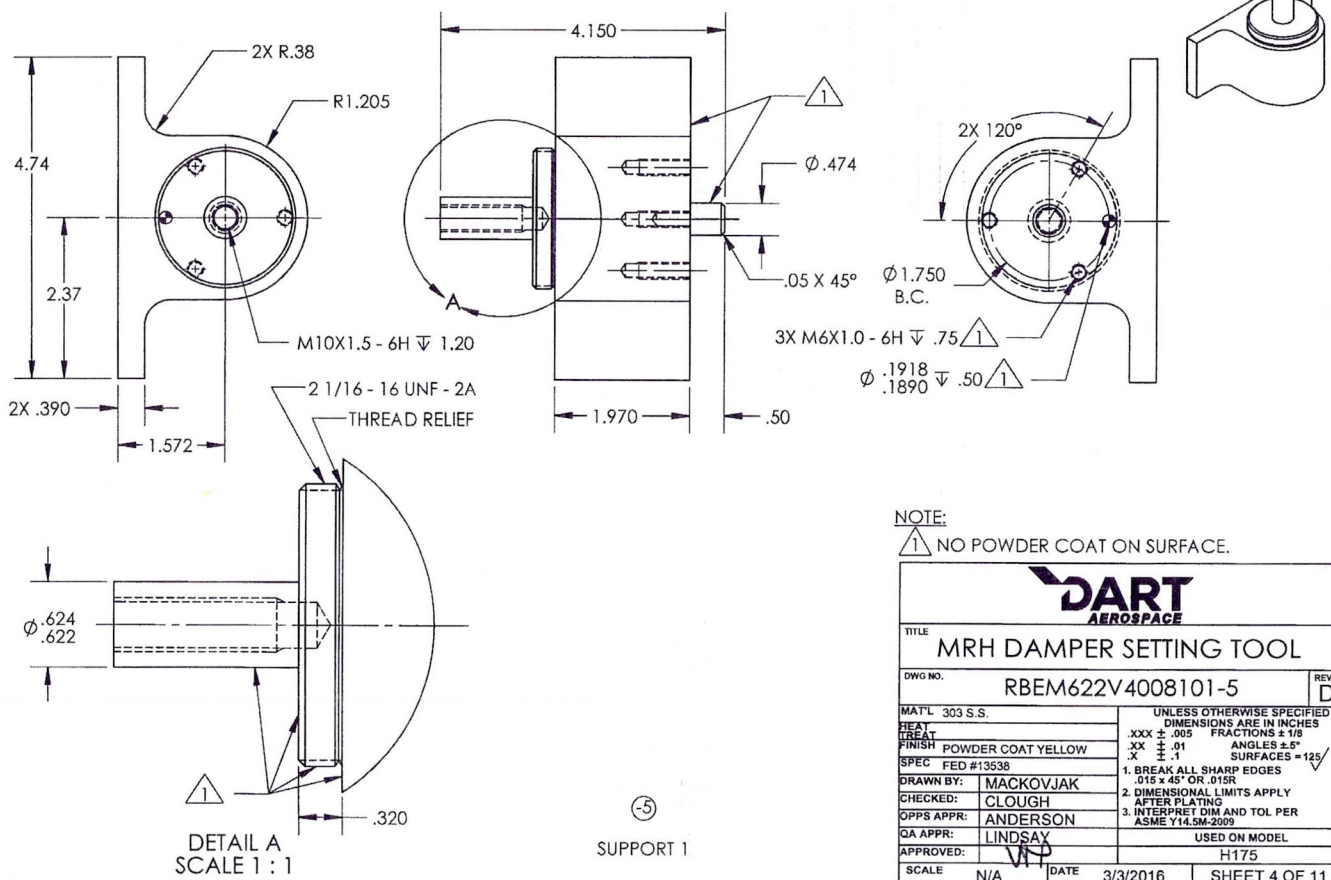
Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
120-NV5000 - 1	M303B3.000X6.000	2	1	0

Part Specifications	
Specifications could not be found.	

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REVISIONS				
REV	ECR	DESCRIPTION	DATE	INITIAL
2	16-0173	-5 CH/D DIM WAS Ø2.165 IS Ø2.165 +.000/-010, ADDED BREAK EDGE NOTE.	10/17/2016	RJC
3	17-0071	-5 CH/D REMOVED DIM Ø2.165+000/-010, 60°, .190, Ø2.087; REMOVED NOTE "BREAK EDGE"; CH/D DIM WAS Ø.630 IS Ø.627/.625; ADDED DIM 2 1/16 - 16 UNF - 2A; ADDED NOTE "THREAD RELIEF"; CH/D MATL WAS A36/1018/1020 HR IS 303 S.S.; REMOVED FINISH ZINC PLATE SPEC. ASTM B633 TYPE 1 SC2.	3/23/2017	SM
D		DIMENSION .627/.625 CHANGED FOR .624/.622	2/20/2019	VM



NOTE:
1 NO POWDER COAT ON SURFACE.

DART AEROSPACE	
TITLE MRH DAMPER SETTING TOOL	
DWG NO. RBEM622V4008101-5	REV D
MATL 303 S.S.	UNLESS OTHERWISE SPECIFIED
HEAT TREAT	DIMENSIONS ARE IN INCHES
FINISH POWDER COAT YELLOW	XXX ± .005 FRACTIONS ± 1/8
SPEC FED #13538	XX ± .01 ANGLES ± 5°
DRAWN BY: MACKOVJAK	X ± .1 SURFACES = 125/
CHECKED: CLOUGH	1. BREAK ALL SHARP EDGES
OPPS APPR: ANDERSON	.015 X 45° OR .015R
QA APPR: LINDSAY	2. DIMENSIONAL LIMITS APPLY
APPROVED: WSP	AFTER PLATING
SCALE N/A	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
DATE 3/3/2016	USED ON MODEL
	H175
SHEET 4 OF 11	

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
				QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					

